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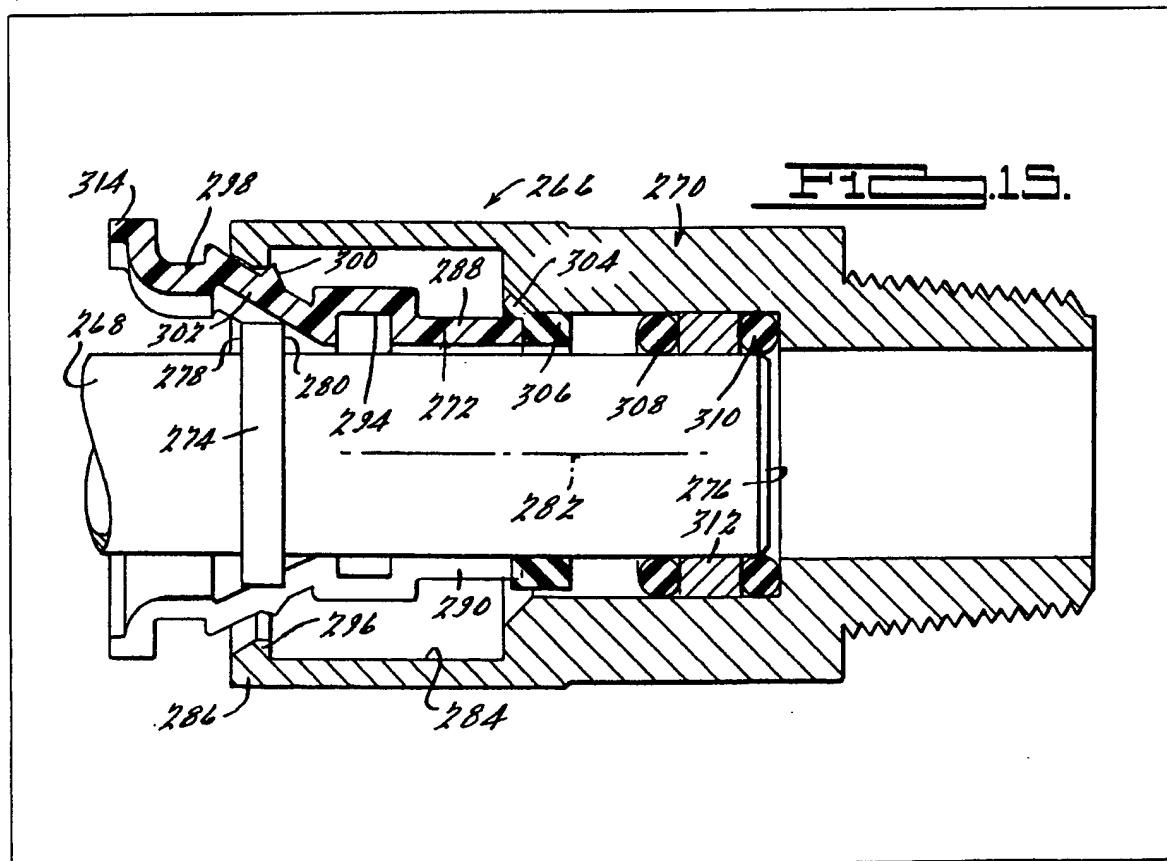
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(54) **Swivable quick connector**

(57) A swivable quick connect assembly comprises a housing 270 having an axial bore for receiving one end of a conduit 268, elastomeric ring-like seals 308, 310 are disposed in the bore for providing a

fluid tight seal between confronting portions of the conduit and the housing, an annular bushing 306 is disposed in the bore for positioning the seal and for guiding the one end of the conduit into nesting relationship with the bore, and a retainer 272 is detachably secured to the housing and is cooperable with an annular projection 274 on the conduit for securing the conduit in its operative position within the bore, the retainer having resilient deformable portions 288, 290 which are adapted to snap over the locking wall upon insertion of the conduit into the housing bore.



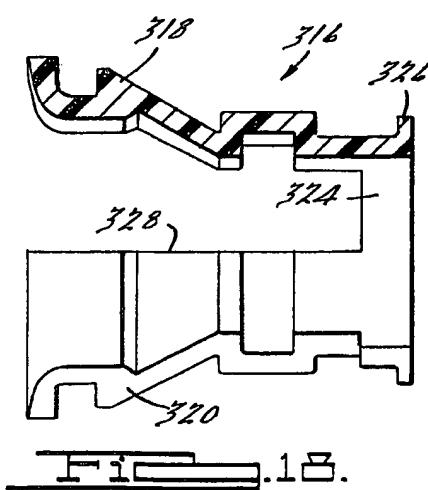
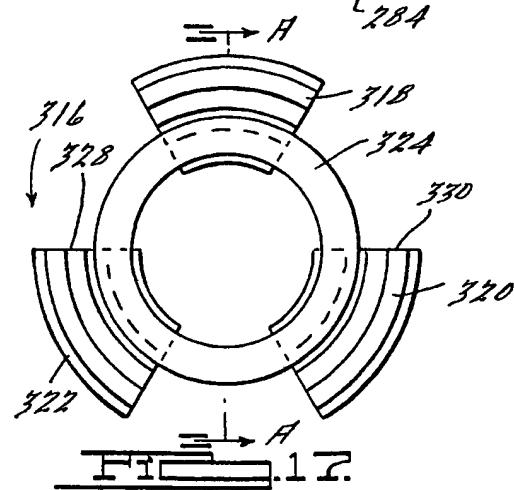
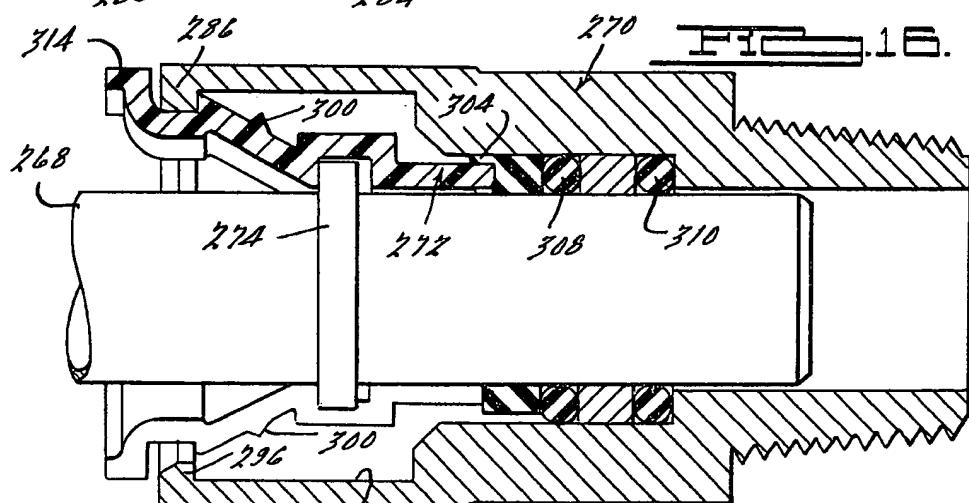
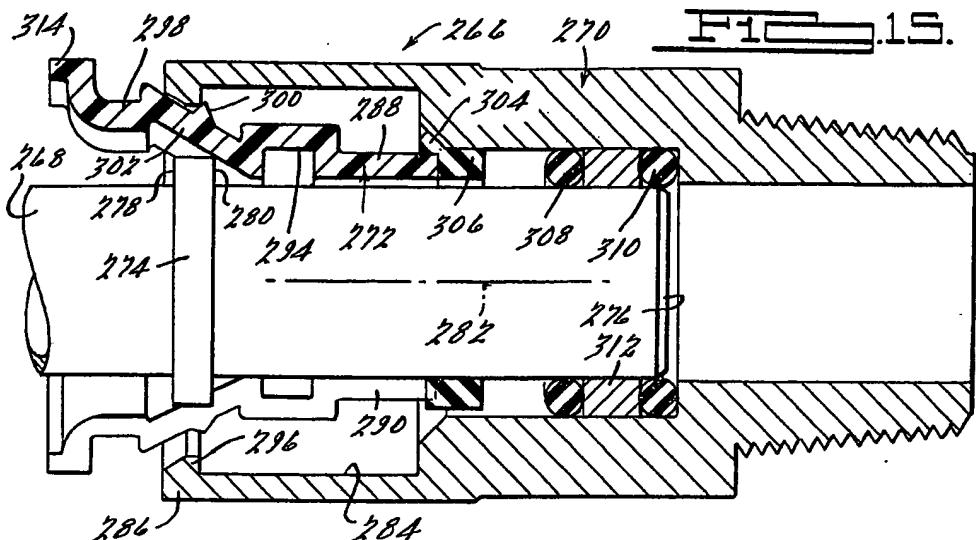
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The drawings originally filed were informal and the print here reproduced is taken from a later filed formal copy.

The reference to Figures 1–14 of the drawings in the printed specification are to be treated as omitted under Section 15(2)/(3) of
the Patents Act 1977

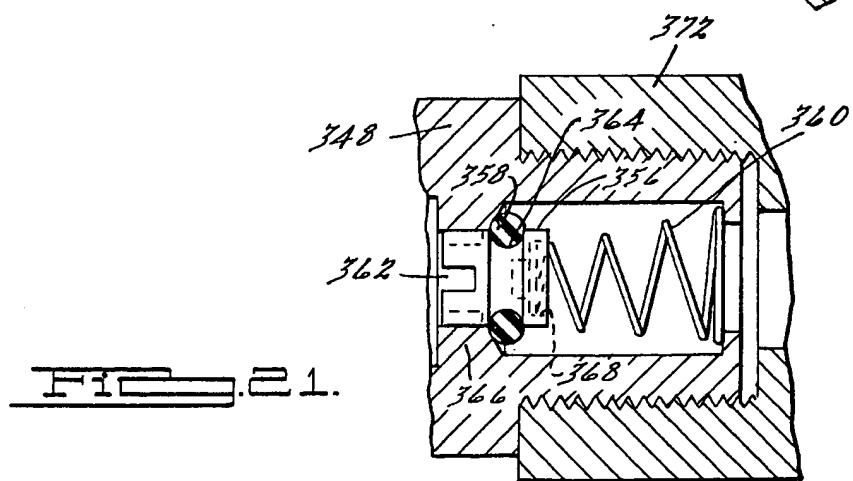
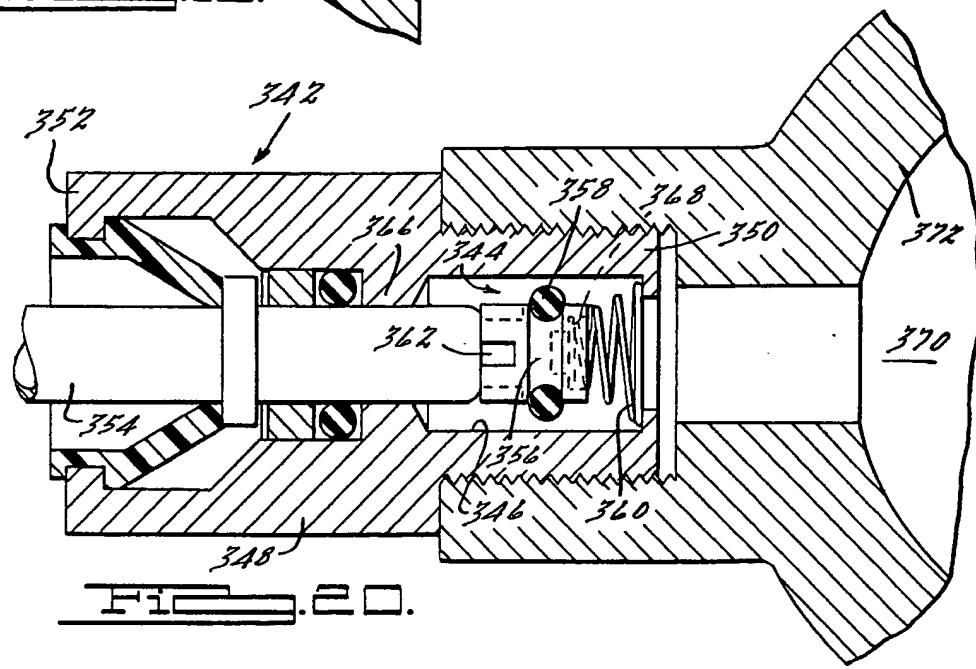
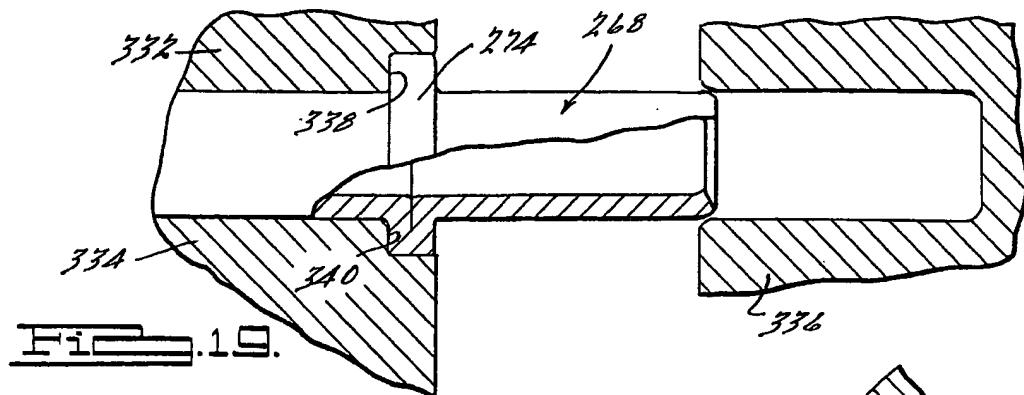
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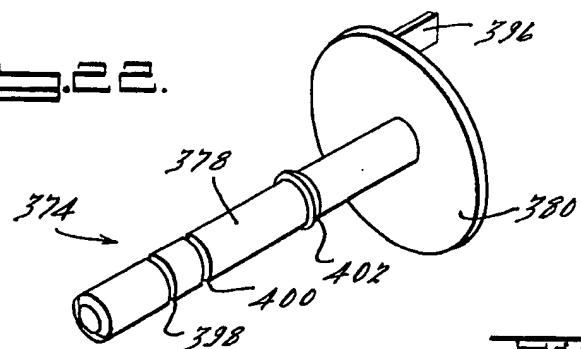
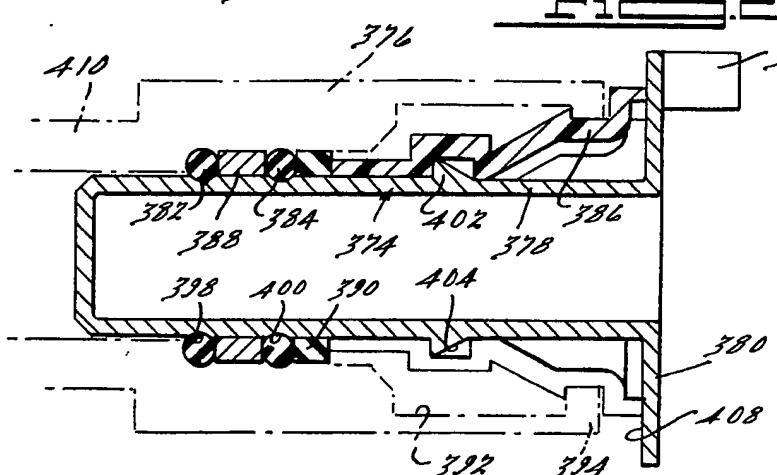


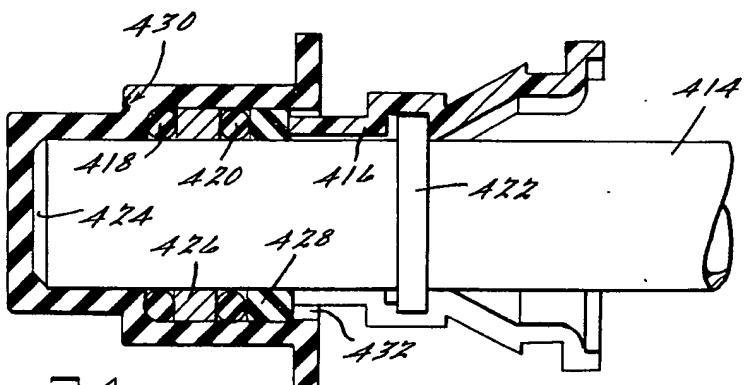
FIG. 23.



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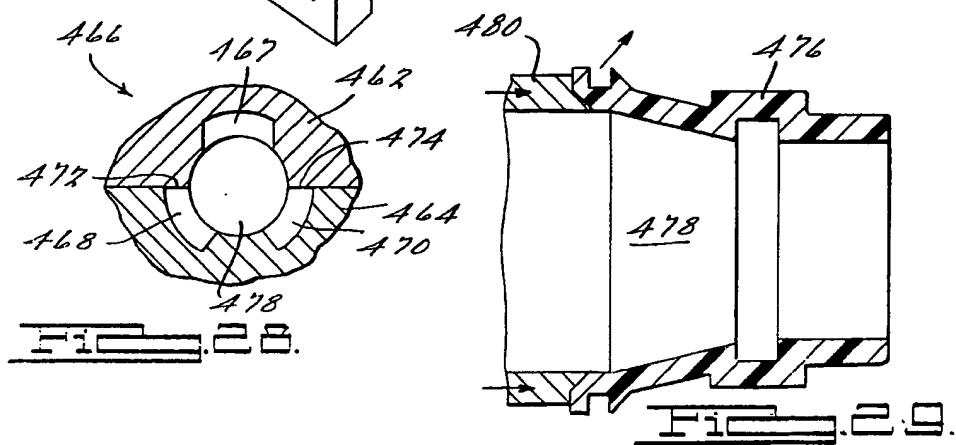
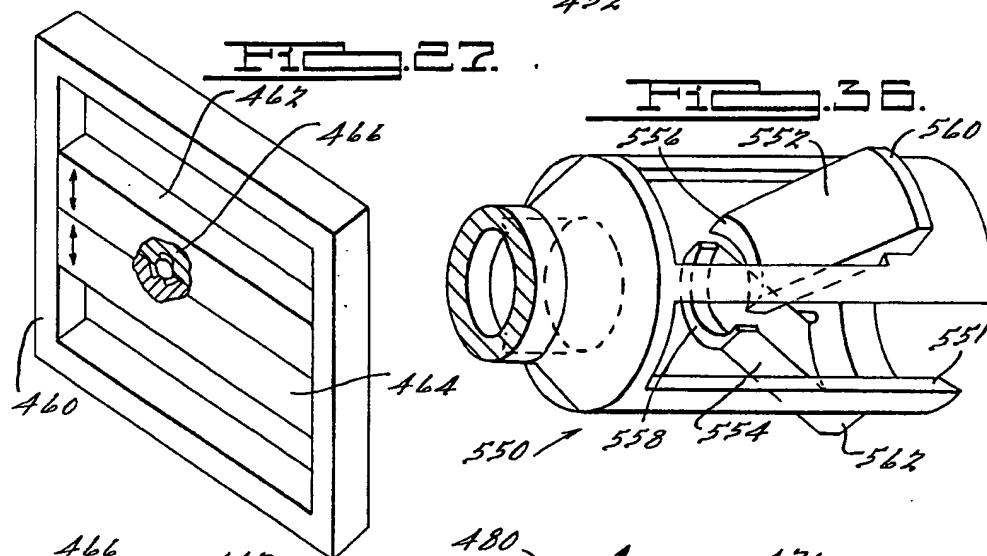
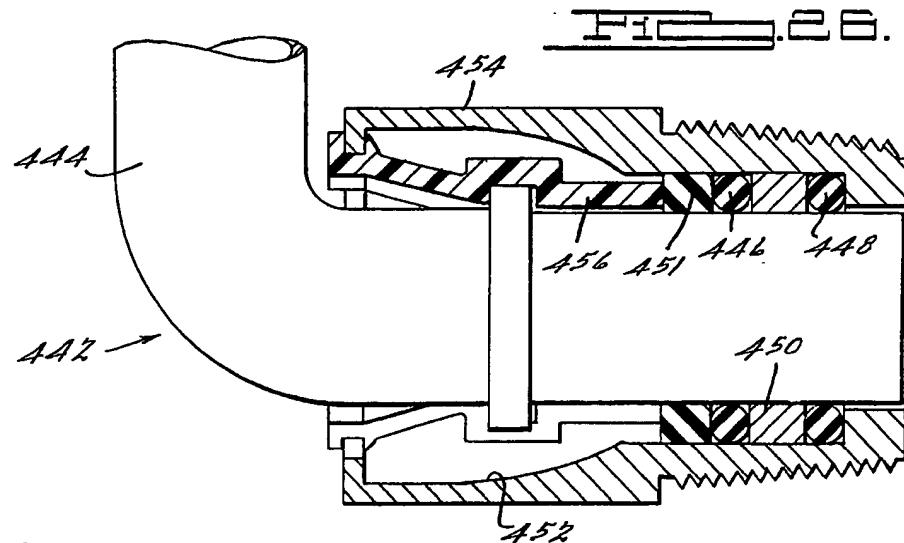
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Fig. 30.

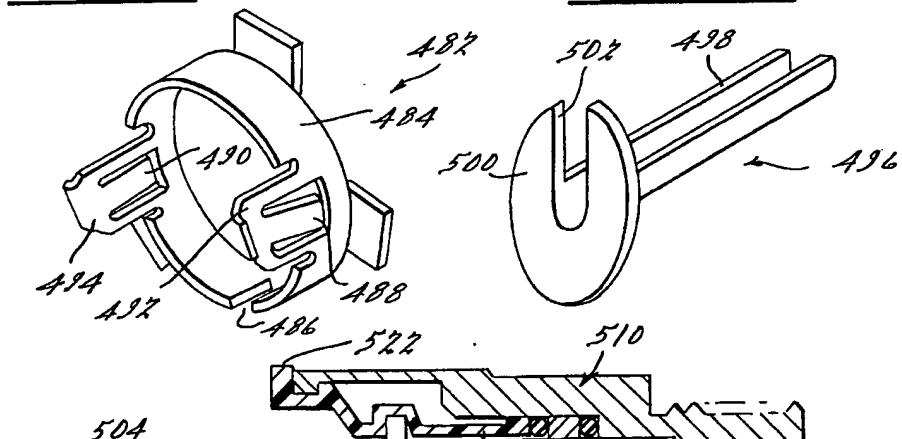


Fig. 31.

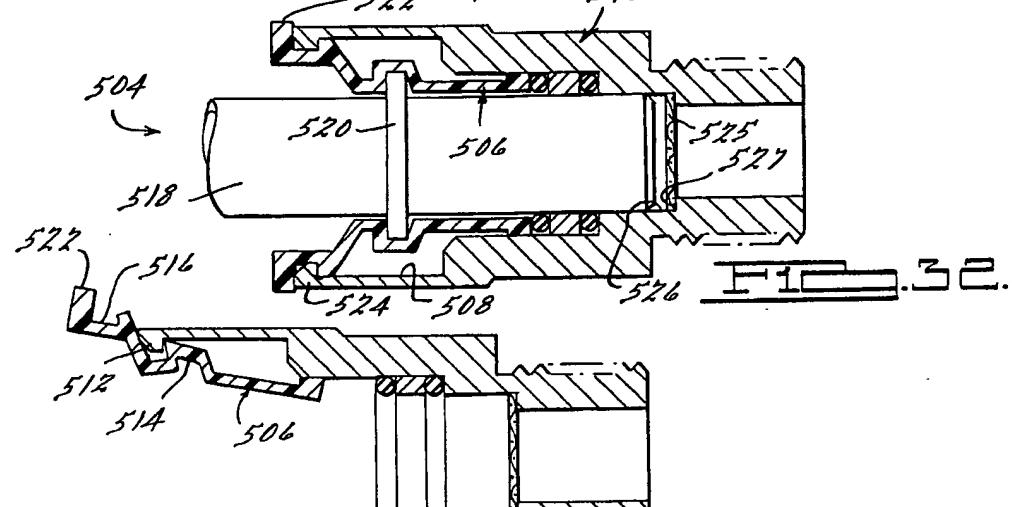


Fig. 32.

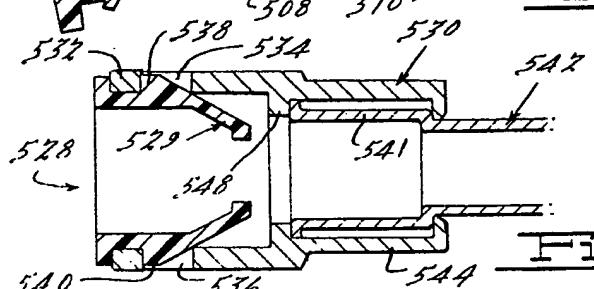


Fig. 33.

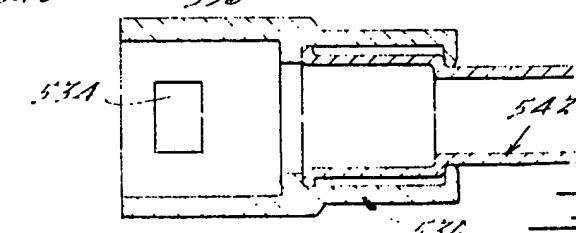


Fig. 34.

Fig. 35.

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SPECIFICATION**A swivable quick connector assembly**

5 The present invention relates to a connector assembly for providing a swivable quick connection.

10 In the automotive industry, as well as for many other industries, the need always exists for low-cost, reliable, and easy to assemble components. This need is especially apparent with respect to providing a connection between fluid carrying conduits, such as a fuel or refrigerant lines. In older threaded connectors, substantial assembly time could be accumulated in screwing on a cap to a fitting and tightening the cap down to the proper torque needed to provide for a fluid tight seal. Further, an inventory would have to be maintained to keep track of the number of caps and fittings, and any liners or other components that may be necessary. Also, retightening of the caps may be required to maintain the seal after the automobile or other system

15 has been put in use.

Accordingly, it is the primary object of the present invention to provide an improved connector assembly for providing a swivable quick connection between fluid conveying

30 conduits.

In addition, it is an object of the present invention to provide a pre-assembled connector housing and retainer element so that a connection to a tubular fluid conveying con-

35duit may be made in one step without resorting to any tools.

Another object of the present invention is to provide a pre-assembled connector housing and retainer element so that a snapping con-

40 nection may be made to a tubular fluid conveying conduit.

Another object of the present invention is to provide a connector assembly that may be employed to join dissimilar electrically con-

45 ducting materials that would be otherwise

subject to galvanic corrosion.

It is a further object of the present invention to provide a connector assembly which is adapted to provide for a bleed-down position

50 when disconnecting a conduit from the housing of the connector assembly.

It is another object of the present invention to provide a pre-assembled connector conduit unit which requires only a one-step snapping

55 connection to be joined to a connector housing.

It is yet another object of the present invention to provide a removable, disposable cover for protecting the pre-assembled connector

60 conduit unit.

It is a further object of the present invention to provide a disposable stuffer-plug for the connector assembly which is adapted to install one or more sealing elements in an axial bore

65 of the connector housing and detachably se-

cure a retainer element to the connector housing, as well as to seal the axial bore of the connector housing.

It is still a further object of the present

70 invention to provide a connector assembly which employs a check valve unit disposed in the axial bore of the housing for selectively blocking fluid flow.

It is also an object of the present invention

75 to provide an improved retainer element which operates to both secure the conduit in the axial bore of the housing and position the sealing element within the axial bore of the housing.

80 It is a more specific object of the present invention to provide an improved retainer element formed with three or more leg members which operate to detachably secure the retainer element to the housing, the sealing

85 means within the housing, the conduit in its operative position within the axial bore of the housing, and provide better resistance to off axis forces on the conduit.

To achieve the foregoing objects, the present invention provides a swivable connector assembly which generally comprises a tubular conduit, a housing, sealing means, and retainer means. The tubular conduit is adapted to convey fluid and is formed with an annular 95 projection disposed a predetermined distance from the end of the conduit to be connected. The housing is formed with an axial bore for receiving the conduit at a first end and for providing a fluid path at a second end, and

100 includes an inwardly extending annular lip (or suitable apertures) at the first end to detachably secure the retainer means to the housing. The sealing means is disposed within the axial bore of the housing for providing a fluid

105 tight seal between confronting portions of the conduit and the housing. The retainer means is adapted to be disposed generally within the axial bore of the housing for cooperating with the annular projection of the conduit to secure

110 the conduit in its operative position within the axial bore of the housing. The retainer means includes three or more circumferentially spaced resilient deformable leg members which extend from an integral collar member

115 at one end thereof. Each of the leg members has an outwardly opening channel portion which is adapted to receive the inwardly extending lip of the housing to secure the retainer means to the housing, and an inwardly 120 opening channel portion adapted to receive the annular projection of the conduit for securing the conduit in its operative position within the axial bore of the housing. The ring from which the legs extend may additionally serve

125 to position and retain the sealing means.

Additional objects and advantages of the present invention will become apparent from reading of the detailed description of the preferred embodiments which makes reference to the following set of drawings in

which:

BRIEF DESCRIPTION OF THE DRAWINGS

5 *Figure 1* is a perspective assembly view of a first embodiment of the present invention.

10 *Figure 2* is a side elevation view, partially in cross-section, of the connector assembly of Fig. 1.

15 *Figure 3* is another view of the connector assembly of Fig. 2, shown in the bleed-down position.

20 *Figure 4* is a perspective view of a second embodiment of a retainer element according to the present invention.

25 *Figure 5* is a front elevation view of a third embodiment of a retainer element according to the present invention.

30 *Figure 6* is a front elevation view of a fourth embodiment of a retainer element according to the present invention.

35 *Figure 7* is a front elevation view of the retainer element of Fig. 6 coupled to a housing according to the present invention.

40 *Figure 8* is a side elevation view, partially in cross-section, of the retainer element and housing of Fig. 7.

45 *Figure 9* is a side elevation view, partially in cross-section, of another embodiment of the connector assembly according to the present invention.

50 *Figure 10* is a perspective view of a fifth embodiment of a retainer element, and its relationship to a conduit is illustrated.

55 *Figure 11* is a side elevation view of another embodiment of the connector assembly according to the present invention.

60 *Figure 12* is a perspective view of the retainer element of Fig. 11.

65 *Figure 13* is a perspective view of another embodiment of the retainer element for the connector assembly of Fig. 11.

70 *Figure 14* is a side elevation view, partially in cross-section of another embodiment of the connector assembly according to the present invention.

75 *Figure 15* is a side elevation view, partially in cross-section, of a connector assembly according to the present invention in a partially installed position.

80 *Figure 16* is a side elevation view, partially in cross-section, of the connector assembly illustrated in Fig. 15 with the tubular conduit shown in its operative position in the axial bore of the housing.

85 *Figure 17* is a front elevation view of an improved retainer element.

90 *Figure 18* is a side elevation view, partially in cross-section, of the retainer element illustrated in Fig. 17, taken along lines A-A.

95 *Figure 19* is a side elevation view, partially in cross-section of the tubular conduit illustrated in Figs. 15 and 16.

100 *Figure 20* is a side elevation view, partially in cross-section, of a connector assembly including a check valve unit shown with the

tubular conduit in its operative position within the axial bore of the housing.

105 *Figure 21* is an enlarged side elevation view, partially in cross-section, of the connector assembly illustrated in Fig. 20, particularly showing the check valve unit when the tubular conduit is not in its operative position within the axial bore of the housing.

110 *Figure 22* is a perspective view of a stuffer-plug according to the present invention.

115 *Figure 23* is a side elevation view, partially in cross-section with the housing shown in phantom, of the stuffer-plug illustrated in Fig. 22 supporting the sealing and retainer elements.

120 *Figure 24* is a side elevation view, partially in cross-section, of a pre-assembled connector conduit unit according to the present invention protected by a removable, disposable cover.

125 *Figure 25* is a fractional side elevation view, partially in cross-section, of a connector assembly employing a U-cup sealing element.

130 *Figure 26* is a side elevation view, partially in cross-section of an elbow connector assembly according to the present invention.

135 *Figure 27* is a perspective view, partially in cross-section, of an apparatus for manufacturing the retainer element illustrated in Figs. 17 and 18.

140 *Figure 28* is a fractional front elevation view of the manufacturing apparatus illustrated in Fig. 27.

145 *Figure 29* is a side elevation view, partially in cross-section, of a core body and ejector forming part of the apparatus of Fig. 27.

150 *Figure 30* is a perspective view of another embodiment of a retainer element.

155 *Figure 31* is a perspective view of a tool which may be used to assist the disconnection of the tubular conduit from the connector housing.

160 *Figure 32* is a side elevation view, partially in cross-section of another connector assembly according to the present invention.

165 *Figure 33* is a cross-sectional side elevation view of the connector assembly illustrated in Fig. 32, particularly showing the retainer element in a partially installed position.

170 *Figure 34* is a cross-sectional side elevation view of another connector assembly according to the present invention.

175 *Figure 35* is a cross-sectional side elevation view of the connector assembly illustrated in Fig. 34, particularly showing the connector housing.

180 *Figure 36* is a perspective view, partially in cross-section, of another embodiment of a connector housing, particularly featuring an integral retainer means.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

185 Referring to Fig. 1, a perspective assembly view of a connector assembly 10 according to

the present invention is shown. The connector assembly is generally comprised of a tubular conduit 12 adapted to convey fluid, a housing 14, and a retainer element 16. Conduit 12 is provided with an outwardly projecting annular surface 18 displaced from a beveled connecting end 20 of the conduit. Annular surface 18 is formed with a blocking wall portion 22 disposed transversely or perpendicularly to a central axis 24 of conduit 12, and a sloping wall portion 26 gradually increasing from an outer surface 28 of the conduit. Housing 14 may have any suitable outer surface shape, and in one form of the present invention, the housing is provided with an enlarged diameter portion 30, a reduced diameter portion 32, and a third diameter portion 34. The housing is adapted to provide for apertures or openings 36 a-d, which are equidistantly spaced around the circumference of enlarged portion 30 of the housing. Apertures 36 are provided to receive and position retainer element 16 transversely to axis 24 of the conduit. The retainer element is made from a resilient material, such as plastic, and is comprised of a pair of generally parallel elongated legs 38 joined at one end by a cross member 40, which provides a separation between the legs approximately equal to the outside diameter of conduit 12. Each retainer leg 38 includes a sloping lead area 42 formed in the interior side of the leg, and a barb 44 projecting from the exterior side of the leg. In addition, each retainer leg further includes a first recess 46 and a second recess 48 formed in the front side of the leg.

Referring to Fig. 2, a side elevation view of connector assembly 10 is shown, partially in cross-section, in a fully assembled position. Housing 14 is shown to be formed with a central bore 50, having an enlarged diameter portion 52, a reduced diameter portion 54, and a third diameter portion 56. Housing 14 also includes a bushing 58 and an elastomeric ring 60 disposed in third diameter portion 56 of housing central bore 50. Bushing 58 also includes a flange portion 62, which extends into enlarged diameter portion 52 of central bore 50. A surface 64 of flange portion 62 is shaped to provide a slope corresponding to sloping wall portion 26 of conduit 12.

In the preferred embodiment, connector assembly 10 may be connected by first coupling retainer element 16 to housing 14, and then inserting connecting end 20 of conduit 12 into central bore 50 of the housing. Retainer element 16 is coupled to housing 14 by inserting legs 38 into apertures 36a and 36b and out through apertures 36c and 36d. Barbs 44 projects outwardly a distance sufficient to engage the upper edges of apertures 36c and 36d and prevent the removal of the retainer element from the housing. Apertures 36 a-d are shaped sufficiently large to permit both an inward and outward deflection of

retainer legs 38. When retainer element 16 is being inserted into housing 14, the retainer legs deflect inwardly to permit barbs 44 to extend through apertures 36c and 36d. When connecting end 20 of conduit 12 is being inserted into bore 50 of housing 14, the retainer legs deflect outwardly to permit annular surface 18 to translate past the retainer legs. Sloping wall portion 26 of annular surface 18 cooperates with sloping lead area of retainer legs 38 to reduce the force required to translate the annular surface past the retainer legs. After conduit 12 is fully inserted into central bore 50 of housing 14, as shown in Fig. 2, retainer legs 38 cooperate with blocking wall portion 22 of annular surface 18 to resist the disconnection or removal of conduit 12 from housing 14.

An important feature of housing 14 is elastomeric ring 60. This ring provides a fluid tight seal between conduit 12 and housing 14, and yet permits the conduit to rotate or swivel relative to the housing. Ring 60 is positioned transversely to axis 24 of conduit 90 12 by bushing 58. Flange portion 62 of bushing 58 provides a means for impeding further insertion of conduit 12 within central bore 50 when surface 64 of flange portion 62 contacts sloping wall portion 26 of annular 95 surface 26 of the conduit.

Referring to Fig. 3, another view of connector assembly 10 is shown. Here, the connector assembly is illustrated in the "bleed-down" position. This feature of the invention 100 may be used to safely disconnect conduit 12 from housing 14 when the fluid pressure is greater than ambient. Accordingly, retainer element 16 is particularly removed or lifted up to the point where first and second recesses, 105 46 and 48 respectively, permit the retainer element to be translated toward a first end 66 of housing 14, in the direction of the arrows shown in Fig. 2. Surfaces 68 and 70 of the retainer recesses will engage the vertical 110 edges of apertures 36 a-d adjacent to housing end 66, and prevent further axial translation of retainer element 16. Conduit 12 may then also be translated toward housing end 66, past the point where elastomeric ring 60 115 contacts conduit end 20. This will interrupt the fluid tight seal, and permit the pressure of the fluid to rapidly decrease. When this seal is broken, legs 38 of retainer element 16 will prevent the total ejection of the conduit from 120 the housing under the force of the fluid pressure by engaging blocking wall portion 22 of annular surface 18. After the fluid pressure has decreased to the ambient pressure, the conduit may then be translated back toward a 125 second end 72 of the housing, so that the retainer element may be removed. The conduit may then be removed from the housing without any obstruction.

Referring to Fig. 4, a second embodiment 130 of a retainer element 74 is shown. Retainer

element 74 is similar to retainer element 16, and the reference numerals for the corresponding components are the same. As in the case of retainer element 16, retainer element 5 74 is an integral element, formed in any conventional manner from a resilient material, such as plastic. The difference between these retainers resides in the lead areas formed in the sides of the legs 38. Retainer element 74 10 is formed with an annular outwardly extending lead area 76 in each of the legs. Lead areas 76 have approximately the same thickness as the thickness of legs 38. Lead areas 76 may extend to the back surface of retainer 15 element 74, or may only partially extend the width of legs 38, as shown in Fig. 4 at reference numeral 78. In contrast, lead areas 42 of retainer element 16 do not outwardly extend. Rather, lead areas 42 are recessed in 20 the interior sides of legs 38 for retainer element 16. Thus, the thickness of legs 38 for retainer element 16 is reduced at the front surface of the legs, and gradually increases to the normal leg thickness at the back surface. 25 Referring to Fig. 5, a third embodiment of a retainer element 80 is shown. Retainer element 80 is also intended for use with housing 14 shown in Fig. 1. Retainer element 80 is made from a resilient material, and is composed 30 of a pair of generally parallel elongated legs 82 joined at one end by a cross member 84, which is extended to form annular members 86. These annular members generally conform to and partially encircle the outside 35 surface of enlarged diameter portion 30 of housing 14. Annular members 86 are each formed with a barb 88 and a handle 90. Legs 82 are each formed with a lead area 92 similar in shape to lead area 42 for legs 38 of 40 retained element 16.

Retainer element 80 is coupled to housing 14 by inserting legs 82 into apertures 36a and 36b. As legs 82 are being inserted, annular members 86 deflect outwardly to permit their translation around the outside surface of housing 14. When the retainer element is fully inserted, barbs 88 will extend inwardly into apertures 36c and 36d to lock the retainer element in place. Handles 90 are 50 used to assist the removal of retainer element 80 from housing 14, which is achieved by deflecting annular member 86 outwardly to disengage barbs 88 from the apertures and lifting the retainer element out from the housing. 55

Referring to Fig. 6, a fourth embodiment of a retainer element 94 is shown. Again, retainer element may be used with housing 14, and is made from a resilient material. Retainer 60 element 94 is comprised of a pair of generally parallel elongated legs 96 joined at one end by a cross member 98. Legs 96 are each formed with an inwardly extending barb 100, and a lead area 102 similar in shape to lead 65 area 42 of retainer element 16. Retainer ele-

ment 94 is coupled to housing 14 by deflecting legs 96 outwardly a sufficient distance to permit their insertion into apertures 36a and 36b and out through apertures 36c and 36d. 70 When fully inserted barbs 100 engage the lower lateral edges of apertures 36c and 36d to lock retainer element in place. Referring to Figs. 7 and 8, retainer element 94 is shown coupled to a housing 104, 75 similar in construction to housing 14. Fig. 7 is a front elevation view and Fig. 8 is a side elevation view partially in cross-section. Housing 104 is provided with an enlarged diameter portion 106 at a first end 108 for 80 receiving a conduit and for mounting retainer element 94, and a reduced diameter portion 110 at a second end 112 for providing a fluid path. Housing 104 is also provided with a third diameter portion 114 interposed between 85 enlarged diameter portion 106 and reduced diameter portion 110. Housing 104 further includes a bushing 116, two elastomeric rings 118 and 120, and an annular sleeve 122 for separating the rings. This 90 housing illustrates that more than one elastomeric ring may be employed to provide a fluid tight seal, as may be required for the particular application of the connector assembly. 95 Referring to Fig. 9, another embodiment of a connector assembly 124 according to the present invention is shown. This embodiment illustrates a housing 126 that may be employed to provide a fluid tight connection 100 between a tubular conduit 128 and a metallic tubular conduit 130. As in the case of conduit 12 of Fig. 1, conduit 128 includes an outwardly projecting annular surface 132, which is formed with a blocking wall portion 134 105 and a sloping wall portion 136. Conduit 130 is formed with an enlarged diameter portion 138, which provides the third diameter portion of the above described housing 14 and 104. Housing 126 is provided with a bushing 110 140, an elastomeric ring 142, and a spacer 144 mounted in enlarged diameter portion 138 of conduit 130. Both bushing 140 and spacer 144 are made from an electrically non-conductive material, such as plastic, and serve 115 an important function when both conduits 128 and 130 are made from dissimilar metals subject to galvanic corrosion. Bushing 140 and spacer 144 support conduit 128 within housing 126 and preclude an end 146 of 120 conduit 128 from contacting a reduced diameter portion 148 of conduit 130. Thus, where the fluid being conveyed is a liquid having the properties of an electrolyte, bushing 140 and spacer 144 prevent the completion 125 of a circuit loop which allow a corrosion current to flow. Housing 126, as well as housing 14 and 104, may be made from either plastic or metal. Any of the retainer elements 16, 74, 80, or 94 may be coupled 130 with housing 126 in the manner described

above.

Referring to Fig. 10, a fifth embodiment of a retainer element 150 is shown in relation to a conduit 152. Retainer element 150 is comprised of two wedge shaped members 154 and 156, which combine to form a jam fit against the blocking wall portion (not shown) of an annular surface 158 of conduit 152. Wedge member 156 is comprised of a pair of generally parallel elongated legs 160 joined at one end by a cross member 162. Similarly, wedge member 14 is comprised of a pair of generally parallel elongated legs 164 joined at one end by a cross member 166. Wedge member 156 further includes an outwardly extending barb 168 formed at the end of each of legs 160. Similarly wedge member 154 includes an outwardly extending barb 170 formed in the side of each of legs 164. The sides of the legs 160 and 164 where wedge members 156 and 154 are joined are reciprocably slanted and formed with serrations, as indicated generally at reference number 172. Retainer element 150 may be coupled to a housing, such as housing 14 of Fig. 1 to force annular surface 158 of conduit 152 securely against a bushing, such as bushing 58 of Fig. 2. Retainer element 150 may be coupled to housing 14 by inserting legs 164 of wedge member 154 into apertures 36a and 36b, and inserting legs 160 of wedge member 156 into apertures 36c and 36d in a similar manner to that described above for retainer element 16. As the wedge members are being inserted, the serrated edges of legs 160 and 164 engage and exert a further insertion force on conduit 152 via annular surface 158. After the wedge members are fully inserted, the serrated edges of legs 160 and 164 fixedly hold the wedge members in their relative positions. It of course should be appreciated by one skilled in the art that conduit 152 may be inserted into housing 14 before the wedge members are coupled to the housing.

Referring to Figs. 11 and 12, another embodiment of a connector assembly 174 according to the present invention is shown. Fig. 12 illustrates a perspective view of a retainer element 176, and Fig. 11 illustrates a side elevation view, partially in cross-section, of the fully assembled connector assembly. Connector assembly 174 is comprised of a tubular conduit 178, a housing 180, and a retainer element 176. Housing 180 may be made from any suitable material, such as plastic or metal, and may have any appropriate outer shape, such as a cylinder or hex construction. Housing 180 is formed with a central bore 182, which provides an enlarged diameter portion 184, a reduced diameter portion 186, and a third diameter portion 188. Housing 180 further includes an inwardly extending flange 190, forming a fourth diameter portion, for mounting retainer

element 176 to the housing. Flange 190 may have a slant shape as shown in Fig. 11 or may have a flat surface. Housing 180 is also provided with a bushing 192, two elastomeric rings 194 and 196, a sleeve 198, and a spacer 200 generally mounted in third diameter portion 188. Retainer element 176 is made from a resilient material, and is comprised of a pair of opposing annular leg members 202 and 204 centrally joined by a recessed ring 206, which positions the retainer element at flange 190 of housing 180. Annular leg 202 is formed with a radially extending tab end 208 on one side of recessed ring 206 and a radially converging jaw end 210 on the other side of the recessed ring. Similarly, annular leg 204 is formed with a radially extending tab 212 on one side of recessed ring 206 and a radially extending tab 214 on the other side. As illustrated in Fig. 11, the distance between annular leg members 202 and 204 at the converging ends corresponds approximately to the outside diameter of conduit 178. Retainer element 176 is coupled to housing 180 by insertion into central bore 182 until flange 190 engages or straddles recessed ring 206. Conduit 178 is then inserted into central bore 182 with an insertion force sufficient to deflect converging jaw ends 210 and 214 outwardly to permit an annular surface 216 of the conduit to be translated past retainer element 176. After conduit 178 is fully inserted into housing 180, converging jaw ends 210 and 214 of retainer element 176 cooperate with a blocking wall portion 218 of annular surface 216 to resist the disconnection or removal of conduit 178 from the housing. Conduit 178 may be removed from housing 180 by compressing extending tab ends 208 and 212 together sufficiently to extend converging jaw ends 210 and 214 apart, so that the conduit may be extracted from the housing without having to remove retainer element 176.

Referring to Fig. 13, another embodiment of a retainer element 220 for the connector assembly of Fig. 11 is shown. Retainer element 220 is made from a resilient material, and is comprised of a ring 222 for mounting the retainer element on flange 190 of housing 180, a pair of opposing jaws 224 and 226 projecting from one side of the ring, and a pair of tabs 228 and 230 projecting from the other side of the ring and positioned on opposite sides of the jaws. Ring 222 is formed with an outer diameter approximately corresponding to the bore diameter provided by flange 190 of housing 180. Jaws 224 and 226 extend beyond the outer diameter of ring 222 at an end 232 and converge at another end 234 to provide a separation approximately corresponding to the outside diameter of conduit 178. When retainer element 220 is coupled to housing 180, flange 190 is interposed between tabs 228 and 230, and ex-

tending end of jaws 224 and 226. Retainer element 220 operates to maintain conduit 178 in housing 178 in a similar manner to that described above for retainer element 5 176. However, retainer element 220 is of a simplified design in that the retainer element is not provided with an integral means to assist the removal of conduit 178 from housing 180.

10 Referring to Fig. 14, another embodiment of a connector assembly 236 according to the present invention is shown. Connector assembly 236 represents a union-type connector, and is essentially a duplicate of the structure described above for the previous embodiments. Generally, connector assembly 236 is comprised of two conduits 238 and 240, a housing 242, and a pair of retainer elements 244 and 246. Housing 242 includes a pair of 15 bushings 248 and 250, a set of four elastomeric rings 252-258, a pair of sleeves 260 and 262, and a central spacer 264.

Referring to Fig. 15, a side elevation view 20 of a connector assembly 266 is shown, partially in cross-section, in a partially installed position. The connector assembly 266 includes a tubular conduit 268, a housing 270, and a retainer element 272. The conduit 268 is formed with an annular projection 274 disposed a predetermined lead distance from an end 276 of the conduit to be connected. It should be noted that the annular projection 274 is symmetrical in shape, in that the 25 opposing surfaces 278 and 280 of the projection are generally transverse to a central axis 282 of the conduit 268 and generally parallel each other.

The retainer element 272 is adapted to be 30 disposed generally within an axial bore 284 of the housing 270 and is detachably secured to the housing at a first end 286 of the housing. The retainer serves to secure the conduit 268 in its operative position within the axial bore 284 of the housing 270 by cooperating with 35 the annular projection 274 of the conduit.

The retainer element 272 includes three circumferentially spaced resilient, deformable leg members, of which only two leg members 288 and 290 are shown in Fig. 1. These leg 40 members extend from an integral collar member 292 at one end of the retainer element 272. The collar member 292 is adapted to provide an opening sufficient to permit the end 276 of the conduit to pass therethrough.

50 Each of the leg members is formed with an inwardly opening channel portion 294 which is adapted to receive the annular projection 274 of the conduit 268 for securing the conduit in its operative position within the axial bore 284 of the housing 270. The shape of the inwardly opening channel portion 294 of the leg members is generally complimentary to the shape of the annular projection 274 of the conduit. Although various suitable 55 shapes may be provided for the inwardly

opening channel portion 294 and the annular projection 274, the shapes should be such as to lock the conduit into the axial bore 284 of the housing and prevent or limit axial movement of the conduit relative to the housing. Each of the leg members are also formed with an outwardly opening channel portion 296 which is adapted to receive an inwardly extending annular lip 298 of the housing to 70 secure the retainer element 272 to the housing. The shape of the outwardly opening channel portion 298 of the leg members and the annular lip 296 of the housing are subject to the same considerations noted above for 75 the inwardly opening channel portion 294 of the leg members and the annular projection 274 of the conduit 268. However, it may also be noted that rather than forming the annular lip 296 of the housing 270 by casting or 80 milling, the annular lip may also be formed by rolling in the first end 286 of the housing.

The leg members (288, 290) of the retainer element 272 are adapted to deform in response to the insertion of the retainer element 90 into the axial bore 284 of the housing 270 and permit the annular lip 296 of the housing to snap into the outwardly opening channel portion of each of the leg members. Similarly, the leg members of the retainer element 272 95 are adapted to deform in response to the insertion of the conduit 268 into the axial bore 284 of the housing 270 and through the collar member 292 of the retainer element 272, and permit the annular projection 274 100 of the conduit to snap into the inwardly opening channel portion 294 of the leg members. However, one feature of the connector assembly 266 is that the annular projection 274 of the conduit is adapted to snap into the 105 inwardly opening channel portion 294 of the leg members (288, 290) before the annular lip 296 of the housing 270 snaps into the outwardly opening channel portion 298 of the leg members. This feature will permit the 110 annular projection 274 of the conduit to easily snap into the inwardly opening channel portion 294 of the leg members. This feature is achieved by providing for two sets of tabs which cooperate to maintain the retainer element 272 in the partially installed position shown in Fig. 1 until the annular projection 274 of the conduit 268 has snapped into the inwardly opening channel portion 294 of the retainer element leg members. The first set of 115 tabs 300 extend outwardly along an inclined portion 302 of the retainer element leg members, and operate to prevent the retainer element 272 from falling out of the axial bore 284 of the housing 270. One or more first 120 tabs 300 may be provided on each of the retainer element leg members as may be appropriate in the particular application. The second set of tabs 304 are formed to extend generally outwardly from a bushing 306 125 disposed within the axial bore 284 of the hous- 130

ing 270. The second tabs 304 are shaped such that they will resist the further insertion of the retainer element 272 into the axial bore 284 from the partially installed position until 5 the annular projection 274 snaps into the inwardly opening channel portion 294 of the retainer element. However, once the conduit 268 is thus joined or united to the retainer element 272, the second tabs 304 will yield 10 and deflect inwardly to permit the further insertion of the conduit 268 and the retainer element 272 into the axial bore 284 of the housing 270 until the annular lip 296 of the housing snaps into the outwardly opening 15 channel portion 298 of each of the retainer element leg members and the conduit is in its operative position with the axial bore of the housing. Fig. 2 illustrates the connector assembly 266 with the conduit 268 shown in 20 its operative position within the axial bore 284 of the housing 270.

The connector assembly 266 also includes two elastomeric rings 308 and 310 disposed within the axial bore 284 of the housing 270 25 for providing a fluid tight seal between confronting portions of the conduit 268 and the housing. The elastomeric rings are also separated by a suitable sleeve 312. It should be noted that once the conduit 268 is connected 30 to the housing 270 via the retainer element 272, the conduit may be subsequently released and withdrawn from the axial bore 284 of the housing as follows. By manually deflecting each of the retainer element leg 35 members at a finger portion 314 (extending out of the bore 284 of the housing) inwardly toward the central axis 282 sufficiently to disengage the annular lip 296 of the housing from the outwardly opening channel portion 40 298 of the leg members, the conduit 268 and the retainer element 272 will be permitted to slide out of the axial bore of the housing. It should be appreciated that the dimensions of the retainer element 272 and the housing 45 270 relative to the outer diameter of the conduit 268 should be such as to provide sufficient radial clearance between the retainer element and the conduit to permit the deflection of the retainer element leg members 50 necessary for the outwardly opening channel portion 298 to clear the annular lip 296 of the housing. Accordingly, it will be seen that the connector assembly 266 is adapted to readily permit subsequent disconnection of 55 the conduit from the housing. One advantage of this feature of the present invention is that seals may be conveniently replaced without having to replace any of the other components of the connector assembly.

60 Referring to Figs. 17 and 18, a front and a side elevation view of a retainer element 316 is shown. Retainer element 316 is similar to the retainer element 272, in that it generally comprises three circumferentially spaced resilient, deformable leg members 318, 320 and

322, extending from an integral collar member 324 at one end thereof. However, as best illustrated in Fig. 18, the retainer element 316 includes an annular flange 326 extending outwardly from the collar member 324 for positioning the sealing element(s) within the axial bore of the connector housing. Since the flange 326 serves a principal function normally provided by a bushing, it should be 75 appreciated that the need for the bushing may be eliminated in the appropriate application.

As may best be illustrated in Fig. 17, in one form of the present invention the leg members 318-320 are equally spaced circumferentially, and the opposing axially extending edges of any two of the leg members from a substantially straight line. For example, edge 328 of leg member 322 and edge 330 of leg member 320 form a horizontally-extending 85 straight line. Thus it may also be noted that any two of the leg members span a maximum of one hundred and eighty degrees (180°) (including the circumferential space between the leg members). It may also be noted that 90 the provision of three leg members provides certain advantages in relation to a retainer element with either two or four leg members. For example, in order to disconnect a conduit from a housing, the finger portions of a three 95 leg retainer element will be easier to grasp than a four leg retainer element. Additionally, a three leg retainer element will provide greater circumferential engagement than a two leg retainer element. Furthermore, with a 100 two leg retainer element, a larger diameter connector housing will be required relative to a three leg retainer element in order to permit the leg members to expand around the annular projection of the conduit.

105 With respect to the materials from which retainer elements 272 and 316 may be constructed, flexible thermoplastic or metal spring stock which will withstand the temperature and chemical environment expected to be 110 encountered in the application is preferred. For example, typical nylons which are considered to be useful are types 6, 6-6, 6-10, 6-12, 11 and 12. It may also be appropriate to add glass reinforcement up to 30% for 115 increased strength in the particular application.

Referring to Fig. 19, a side elevation view of the tubular conduit 268 of Fig. 15 is shown, partially in cross-section. In particular, 120 the conduit 268 is shown in relation to a set of forming dies 332, 334 and 336, which are used to form or coin the annular projection 274 of the conduit. Briefly, forming dies 332 and 334 clamp the conduit on one side of the 125 projection to be formed, and the forming die 336 slides over or clamps the other side of the conduit. Then, as the forming die 336 is drawn into engagement with the forming dies 332 and 334, the conduit will buckle outwardly and conform itself to the shape of the 130

recesses 338 and 340 provided in the forming dies 332 and 334 respectively. It should be noted that this type of annular projection provides certain manufacturing advantages 5 over previous projections having a sloping or tapered lead-in portion, including the use of higher forming forces and easier tolerances to maintain.

Referring to Fig. 20, a side elevation view 10 of a connector assembly 342 is shown partially in cross-section. The connector assembly 342 features a check valve unit 344, which is disposed in an axial bore 346 of a housing 348. The check valve unit 344 operates to 15 block the flow of fluid from a second end 350 of the housing 348 to a first end 352 of the housing when the conduit 354 is not in its operative position within the axial bore 346 of the housing. It should be noted that Fig. 20 20 illustrates the connector assembly with the conduit 354 in its operative position, while Fig. 21 illustrates an enlarged portion of the connector assembly where the conduit is not in its operative position. When the conduit 25 354 is in its operative position, the check valve unit 344 also operates to permit the flow of fluid between the first end 352 and the second end 350 of the housing 348.

Before proceeding to describe the check valve 30 unit 344, it may be worthy to note that it may be used with a variety of retainer elements, and the particular retainer element illustrated in Fig. 20 (similar to that of Fig. 13) is intended for exemplification only.

The check valve unit 344 generally comprises a valve body 356, an elastomeric ring 358, and a helical compression spring 360. The valve body 356 is formed with a plurality of generally axially extending, circumferentially spaced passageways or notches 362 for selectively permitting fluid to flow to or from the conduit 354. The elastomeric ring 358 is seated in an annular groove 364 of the valve body 356 such that when the conduit 354 is 45 not in its operative position within the axial bore 346 of the housing 348, the elastomeric ring is in sealing engagement with a neck portion 366 of the housing. Accordingly, the elastomeric ring 358 is associated with the 50 valve body 356 such that it is operative to block the flow of fluid from the second end 350 of the housing 348 through the passageways 362 in the valve body when the conduit 354 is not in its operative position within the 55 axial bore 346 of the housing. The helical compression spring 360 is adapted to have one end seated in a circular groove 368 of the valve body and the other end in engagement with the housing 348 (generally at the second end 350 thereof). The spring 300 60 operates to resiliently urge the valve body 356 into a nesting relationship with the housing 348 (as shown in Fig. 21) when the conduit 354 is not in its operative position, 65 thereby causing the elastomeric ring to block

fluid flow. However, the spring 360 also operates to permit the valve body 356 to be displaced axially from the nesting relationship by yieldably resisting the insertion of the 70 conduit into the axial bore 346 of the housing, thereby permitting fluid flow through the passageways 362 in the valve body when the conduit is in its operative position within the axial bore of the housing. It should be noted 75 that the provision of the check valve unit 344 is connector assembly 342 will permit an area 370 in a device 372 to be charged with a fluid before the device is shipped in an application where the conduit 354 is to be connected after shipment of the device.

Referring to Fig. 22, a perspective view of a stuffer-plug 374 according to the present invention is shown. The stuffer-plug 374 is intended to be disposable and is preferably 85 made from a plastic material. The stuffer-plug 374 serves three principal functions, which may best be illustrated with reference to Fig. 23. Briefly, the stuffer-plug 374 is used to 90 install one or more sealing elements in the axial bore of a housing and detachably secure a retainer element to the housing. The stuffer-plug 374 also serves to seal the axial bore of the housing.

Fig. 23 is a side elevation view of the 95 stuffer-plug 374, partially in cross-section, shown to be disposed in a housing 376 (in phantom lines). The stuffer-plug 374 is comprised of a body which is formed with a rod-shaped portion 378 and a facing portion 380 100 extending generally from one end of the rod-shaped portion. The rod-shaped portion is adapted to support sealing elements 382 and 384, and a retainer element 386 in a generally coaxial assembly relationship thereon. The 105 rod-shaped portion 378 may also be used to support a sleeve 388 and a bushing 390 in the appropriate application. The rod-shaped portion 378 is also adapted to be inserted into an axial bore 392 of the housing 376 110 and preferably has an outer diameter generally corresponding to that of the conduit to be connected to the housing. The rod-shaped portion may be either a solid rod or tubular in construction, provided that the tube is closed 115 at some point in order to seal the axial bore 392.

The facing portion 380 of the stuffer-plug body is adapted to cover or substantially cover the axial bore 392 of the housing 376 at a 120 first end 394 thereof. In one form of the present invention, the facing portion 380 is a circular plate extending generally transversely from the rod-shaped portion 378, and the facing portion is formed with a generally axially extending tab 396 for facilitating the removal of the stuffer-plug 374 from the axial bore 392 of the housing 372. The rod-shaped portion 378 is also formed with two annular grooves 398 and 400 which seat the elastomeric ring sealing elements 382 and 384 re-

spectively. The annular grooves 398 and 400 provide positioning means for maintaining the sealing elements 382 and 384 and the retainer element 386 in the assembly relationship on the stuffer-plug body until the stuffer-plug body is removed from the axial bore 392 of the housing 376. The annular grooves 398 and 400 operate to prevent the sealing and retainer elements from slipping off the stuffer-plug body before the rod-shaped portion 378 is inserted into the axial bore 392 of the housing, and yet also permits the sealing and retainer elements to slide off the rod-shaped portion when the stuffer-plug body is removed from the housing. It should be noted that it may only be necessary to provide for one annular groove in the rod-shaped portion 378, or provide for one or more annular projections instead of the annular grooves in the appropriate application. The rod-shaped portion 378 may also include an annular projection 402 formed with an inclined surface 404 for cooperating with the retainer element 386 to prevent the retainer element from slipping off the stuffer-plug body before the rod-shaped portion is inserted into the axial bore of the housing. The inclined surface 404 operates to facilitate the removal of the stuffer-plug body from the axial bore 392 of the housing 376 by causing a gradual outward deflection of the retainer element leg members as the stuffer-plug body is pulled out of the axial bore until the inwardly opening channel portion 406 of the retainer element leg members clears the annular projection 402.

The sealing elements 382-384 and the retainer element 386 are preferably disposed on the rod-shaped portion 378 in the assembly relationship such that one end of the retainer element is positioned adjacent to the facing portion 380 and the sealing elements 382-384 are positioned adjacent to the opposite end of the retainer element. Accordingly, the facing portion 380 will provide a blocking surface 408 upon which the retainer element 386 is adapted to bear against when the stuffer-plug body is inserted into the axial bore 392 of the housing. Thus, when the rod-shaped portion 378 is inserted into the axial bore 392 of the housing 376, the sealing elements 382-384 and the retainer element 386 will be carried with the rod-shaped portion until the retainer element is detachably secured to the housing. It should be appreciated that once the rod-shaped portion 378 is in its operative position within the axial bore 392 of the housing (as shown in Fig. 23), the sealing elements 382-384 will operate to provide a fluid tight seal between confronting portions of the rod-shaped portion and the housing. In this position, the housing 376 or the device to which the housing is mounted is prepared for shipment and subsequent connection to a conduit. Additionally, in order to connect the conduit to the housing 376, the

operator simply withdraws the stuffer-plug 374 from the housing and inserts the conduit in its place. Until that time, the stuffer-plug 374 will seal the axial bore 392 of the 70 housing 376 from dirt or other environmental contamination.

It should be noted that with the sealing elements 382-384 and the retainer element 386 disposed on the rod-shaped portion of 75 the stuffer-plug body in an assembled relationship, this combination of components forms a preassembled stuffer-plug unit for insertion into the axial bore of a housing. It may also be pointed out with reference to Fig. 23 that 80 the housing 376 is not provided with external threads at the second end 410 thereof. This is to illustrate that the housing 376 may form part of an integral cast body, such as an engine block for example.

85 Referring to Fig. 24, a side elevation view of a preassembled connector conduit unit 412 is shown, partially in cross-section. The connector conduit unit 412 generally comprises a tubular conduit 414, a retainer element 416 and one or more sealing elements 418 and 420. The retainer element 416 is disposed on the conduit 414 in association with an annular projection 422 of the conduit such that the retainer element is fixed or substantially fixed 90 from axial movement in relation to the conduit. The sealing elements 418-420 are disposed on the conduit 414 between an end 424 of the conduit to be connected and the retainer element 416. A sleeve 426 and a 95 bushing 428 may also be disposed on the conduit (as illustrated) in the appropriate application. The connector conduit unit 412 is also shown to include a removable, disposable cover 430 adapted to encompass at least the 100 end 424 of the conduit to be connected. In one form of the present invention, the cover 430 is constructed from an elastomeric material and is adapted to encompass the sealing elements 418-420 and a portion of the retainer element 416. The cover 430 serves to 105 protect the end 424 of the conduit to be connected and the sealing elements 418-420 from dirt or other environmental contamination before the connector conduit unit 412 is 110 inserted in the axial bore of a housing. The cover 430 should be resilient and flexible, and have an aperture 432 formed therein for permitting the cover body to pass over the end 424 of the conduit to be connected and 115 the sealing elements 418-420. The cover 430 may be subsequently removed and disposed of when the conduit 414 is to be inserted into an axial bore of a housing. When the conduit 414 is inserted into an axial bore 120 of a housing to unite the conduit to the housing, it should be noted that this one-step action will concomitantly install the sealing elements 418-420 in the axial bore of the housing and detachably secure the retainer 125 element 416 to the housing.

Referring to Fig. 25, a fractional side elevation view of a connector assembly 434, partially in cross-section, is shown. Connector assembly 434 features a resilient, flexible U-5 cup sealing element 436 disposed within an axial bore 438 of the connector housing 440. Accordingly, Fig. 25 serves to illustrate that various types of conventional sealing elements 10 may be employed, including X-section and box-section sealing elements.

Referring to Fig. 26, a side elevation view of an elbow connector assembly 442 is shown, partially in cross-section. Fig. 26 serves to illustrate that a bend (approximately 15 90 degrees) in a tubular conduit 444 will permit a connector assembly as previously described to form an elbow connector assembly and eliminate the need for a separate elbow connector. Fig. 26 also serves to illustrate that without the conduit 444, the remaining components of the connector assembly 442 provide a pre-assembled connector conduit unit. In other words, with the sealing elements 446-448, the sleeve 450 20 and the bushing 451 disposed in the axial bore 452 of the connector housing 454, and the retainer element 456 detachably secured to the housing, then the conduit 444 may be united to the housing in a one-step snapping 25 connection. Fig. 26 further serves to illustrate that the axial bore 452 of the housing 454 may be sloped in the appropriate application.

Referring to Fig. 27, a perspective view of an apparatus 458 for manufacturing the retainer elements of the type illustrated in Figs. 35 15-18, 23-24 and 26 is shown. The apparatus 458 has been simplified for illustrative purposes, and includes a frame structure 460 and a pair of vertically movable opposing dies 40 462 and 464. The apparatus is an injection moulding machine for manufacturing a plurality of plastic retainer elements simultaneously. Fig. 28 is a fractional front elevation view, 45 partially in cross-section, of a portion 466 of the apparatus 458. Fig. 28 particularly illustrates the relationship of the dies 462-464 to the leg members 467, 468 and 470 of one of the retainer elements being molded. It is important to note that the edge 472 of leg 50 member 468 and the edge 474 of leg member 470 are formed along the junction of dies 462 and 464. This feature or particular design of the retainer element permits the use of a two-die injection moulding apparatus in- 55 stead of a three-die injection moulding apparatus, and consequently allows several retainer elements to be molded at the same time in one apparatus. It should be noted that the shape or angle of the other edges of the 60 retainer element leg members and the separation between the leg members is a matter of design choice, so long as two of the leg members may be formed within a single die and the leg members will not be locked into 65 the dies after they are formed.

As may be best illustrated with reference to Fig. 29, the retainer element 476 is molded around a core body 478 which is inserted into a suitable cavity between the dies 462 and 70 464. The core body 478 has a shape which conforms to the desired interior shape and dimensions of the retainer element 476, while the cavities of the dies 462 and 464 have a shape which corresponds to the desired exterior 75 shape and dimensions of the retainer element. After the plastic has been injected and sufficiently hardened, the dies 462 and 464 open and an ejector member 480 of the apparatus is translated axially in the direction 80 of the arrows to urge the outward deflection of the leg members 467-470, such that the retainer element 476 may be readily removed from the apparatus 458.

Referring to Fig. 30, a perspective view of another retainer element 482 is shown. In the embodiment illustrated, retainer element 482 is preferably manufactured from a metal material. The retainer element 482 features a split ring body 484, having an opening or slot 90 486 for facilitating the removal of the retainer element after it has been attached to a housing. The retainer element 482 also features a pair of spring tabs 488 and 490 extending from one end of the opposing jaw members 95 492 and 494 respectively.

Referring to Fig. 31, a perspective view of a tool 496 is shown which may be used to assist the disconnection of a tubular conduit from a connector housing. The tool 496 comprises a body having a trough-shaped portion 498 and a generally circular-shaped gripping portion 500. The trough-shaped portion 498 is adapted to wrap around or overlie a conduit, and it preferably has a thickness corresponding to the radial height of the annular projection for the conduit. The gripping portion 500 includes a suitable aperture 502 to permit the trough-shaped portion 498 to come into generally continuous engagement 105 with the conduit along its length. It should be noted that the shape of the gripping portion 500 need not be circular, but may be varied provided a sufficient surface is available upon which the necessary axial force may be 110 brought to bear on the trough-shaped section in order to urge the outward deflection of the retainer element leg members or jaws to the point where the conduit may be readily withdrawn from the axial bore of the housing. It 115 should also be appreciated that the cross-sectional span of the trough-shaped portion 498 should be sufficiently circular to engage all the retainer element leg members or jaws, and yet also permit the trough-shaped portion 120 to be fitted over the conduit. It may also be noted that other tools may be developed for releasing the conduit and/or the retainer element from the housing, such as triangular-acting pliers which engage the retainer element 125 leg members at the finger portions and 130

cause them to be deflected inwardly sufficiently to detach the retainer element from the housing.

Referring to Fig. 32, a side elevation view 5 of another connector assembly 504 is shown, partially in cross-section. The connector assembly 504 features a retainer element 506 which is similar to the retainer element 316 of Figs. 17 and 18. In Fig. 32, the retainer 10 element 506 is shown in its operative position generally within the axial bore 508 of the connector housing 510. However, retainer element 506 is also adapted to be disposed in a partially installed position, as illustrated in 15 Fig. 33. In the partially installed position, the retainer element 506 will engage the annular lip 512 of the housing between the inwardly opening channel portion 514 and the outwardly opening channel portion 516 of the 20 retainer element. Accordingly, it should be appreciated that this engagement will operate to maintain the retainer element 506 in this position until the conduit 518 is to be inserted into the axial bore 508 of the housing 25 510. It should be noted that as the conduit is inserted into the axial bore 508 of the housing 510, the annular projection 520 passes freely into the inwardly opening channel portion 514, and the operator should be able to 30 visually observe that the annular projection 520 of the conduit has been received into the inwardly opening channel portions 514 of the retainer element leg members. Upon the further insertion of the conduit 518 into the axial 35 bore 508 of the housing 510, the retainer element 506 will be carried with the conduit until the annular lip 512 of the housing snaps into the outwardly opening channel portions of the retainer element leg members. Al- 40 though each of the leg members of the retainer element 506 is provided with a finger portion 522 extending out of the axial bore 508, this feature of the retainer element may be deleted such that once the conduit 518 is 45 in its operative position within the axial bore of the retainer element will be flush with the first end 524 of the housing and the retainer element will not be visible from the side of the connector assembly. Accordingly, this mo- 50 dification of the retainer element 506 will provide the operator with a visible indication that the conduit is in its operative position and the assembly is complete.

The connector assembly 504 is also pro- 55 vided with a filter or screen 525 which serves to filter particulate matter from the fluid flowing through the bore of the connector assembly. The filter 525 is disposed in a re- 60 duced diameter portion 526 of the bore 508, and is adapted to be interposed between the end of the conduit 518 to be connected and a shoulder 527 of the housing 510. The filter 525 may be made from any suitable material, such as metal wire or plastic mesh. It should 65 be understood that the provision of the filter

525 is not limited to the connector assembly 504, and the filter may be employed in other suitable connector housings.

Referring to Fig. 34, a cross-sectional view 70 of an incomplete connector assembly 528 is shown (the sealing elements and conduit not being illustrated). The connector assembly 528 includes a retainer element 529 detachably secured to a housing 530 at a first end 75 532 thereof. The housing includes a pair of opposing rectangular apertures 534 and 536 through which a pair of outwardly extending portions 538 and 540 of the retainer element 529 extend to secure the retainer element to 80 the housing. The shape of the apertures may be best illustrated with reference to Fig. 35, which particularly illustrates aperture 534. Another feature of the connector assembly 85 528 is the connection of the housing 530 to an expanded section 541 of a tubular conduit 524, generally at the second end 544 of the housing. It should be noted that the conduit 524 may also be a sleeve which is conventionally connected to a tubular conduit. Ad- 90 ditionally, the housing 530 and the conduit 524 may be either made from metal or plastic, and the second end 544 of the housing 530 may be adapted to either snap over or be threaded over the expanded section 541 of 95 the conduit 524. The expanded section 541 of the conduit 524 is also formed with an outwardly extending annular flange 546 which cooperates with a neck portion 548 of the housing 530 to secure the conduit 524 to 100 the housing.

Referring to Fig. 36, a perspective view of a connector housing 550 with an integral retaining means is shown, partially in cross-section. The retaining means is provided by a 105 pair of opposing, inwardly converging jaw members 552 and 554. The jaw members 552 and 554 may be formed concomitantly with the housing 550 in the same molding process or they may be fixedly secured or 110 otherwise attached to the housing 550 such as by a suitable adhesive. The converging ends 556 and 558 of the jaw members 552 and 554, respectively, are shaped to conform to the outer diameter of the conduit to be 115 connected to the housing 550. In one form of the invention, the diverging ends 560 and 562 of the jaw members 552 and 554, respectively, extend radially beyond the outer diameter of the housing 550. However, it 120 should be understood that the shape and number of the leg members may be varied in the appropriate application. It should also be noted that the housing 550 is also formed with at least one, generally axially extending 125 recess 564 for facilitating flexing of the housing and jaw members.

CLAIMS

1. A connector assembly for providing a 130 swivable quick connection, comprising:

5 a tubular conduit adapted to convey fluid, having outwardly projecting annular surface means, formed at a predetermined distance from an end of said conduit to be connected, for providing a blocking wall portion disposed transversely to a central axis of said conduit; 10 a housing having axial bore means formed therein for receiving said conduit at a first end and for providing a fluid path at a second end, elastomeric ring means disposed in said bore means for providing a seal between said conduit and said housing, and annular bushing means disposed in said bore means for positioning said ring means and for guiding 15 the insertion of said conduit into a sealing engagement with said ring means; and a retainer means, demountably coupled to said first end of said housing, for cooperating with said blocking wall portion of said annular surface means to resist the disconnection of 20 said conduit from said housing.

2. The connector assembly according to Claim 1, wherein said bore means provides an enlarged first diameter portion at said first end 25 of said housing, and a reduced second diameter portion at said second end of said housing.

3. The connector assembly according to Claim 2, wherein said bore means provides 30 for a third diameter portion interposed between said first and second diameter portions, having a magnitude less than said first diameter portion and greater than said second diameter portion.

35 4. The connector assembly according to Claim 3, wherein said ring means and said bushing means are disposed in said third diameter portion of said bore means.

5. The connector assembly according to 40 Claim 4, wherein said bushing means includes an enlarged diameter flange portion extending into said first diameter portion of said bore means.

6. The connector assembly according to 45 Claim 5, wherein said flange portion of said bushing means cooperates with said bore means of said housing to impede further axial insertion movement of said conduit within said housing when said annular surface 50 means of said conduit contacts said flange portion of said bushing means.

7. The connector assembly according to Claim 4, wherein said ring means is comprised of at least one elastomeric ring having 55 an outer diameter appropriately greater than said third diameter portion of said bore means and an inner diameter appropriately smaller than the outside diameter of said conduit, so that a fluid tight seal is provided between said 60 conduit and said housing.

8. The connector assembly to Claim 7, wherein said ring means is comprised of two elastomeric rings.

9. The connector assembly according to 65 Claim 8, further including annular sleeve

means disposed in said third portion of said bore means, for separating said elastomeric rings.

10. The connector assembly according to 70 Claim 5, wherein said annular surface means includes a sloping wall portion facing said end of said conduit to be connected and opposing said blocking wall portion.

11. The connector assembly according to 75 Claim 10, wherein said flange portion of said bushing means is formed with a sloping surface corresponding to said sloping wall portion of said annular surface means.

12. The connector assembly according to 80 Claim 2, wherein said retainer means is comprised of a pair of generally parallel elongated legs joined at one end by a cross member formed to provide a separation of said legs approximately equal to said outside diameter 85 of said conduit.

13. The connector assembly according to Claim 12, wherein said housing is adapted to provide for aperture means, opening to said first diameter portion of said bore means, for 90 receiving said legs of said retainer means and for positioning said legs transversely to said axis of said conduit.

14. The connector assembly according to Claim 13, wherein said aperture means is 95 adapted to permit said legs to extend beyond the outside surface of said housing after said retainer means is coupled to said housing.

15. The connector assembly according to Claim 14, wherein said aperture means is 100 comprised of four equidistantly spaced openings.

16. The connector assembly according to Claim 15, wherein said annular surface means is interposed between said legs of said retainer means and said bushing means after 105 said conduit end to be connected is fully inserted into said housing.

17. The connector assembly according to Claim 16, wherein said retainer means is 110 formed from a resilient material, and said legs of said retainer means are deformable.

18. The connector assembly according to Claim 17, wherein said openings of said aperture means are shaped to permit said legs of 115 said retainer means to deflect radially outwardly with respect to said axis of said conduit.

19. The connector assembly according to Claim 18, wherein said retainer means includes barb means, disposed on said legs, for demountably locking said retainer means to 120 said housing.

20. The connector assembly according to Claim 18, wherein said cross member of said 125 retainer means is extended to form annular members generally conforming to and partially encircling said outside surface of said housing.

21. The connector assembly according to 130 Claim 20, wherein each of said annular mem-

ber includes barb means for demountably locking said retainer means to said housing.

22. The connector assembly according to Claim 18, wherein said retainer means is coupled to said housing before the insertion of said conduit into said bore means of said housing.

23. The connector assembly according to Claim 22, wherein each of said legs includes sloping lead means for cooperating with said sloping wall portion of said conduit to reduce the force required to translate said annular surface means of said conduit past said retainer means when connecting said conduit to said housing.

24. The connector assembly according to Claim 21, wherein said retainer means includes recess means, formed in said legs, for cooperating with said aperture means when said retainer means is partially removed from said housing to permit said conduit to be translated to a bleed down position within said bore means of said housing.

25. The connector assembly according to Claim 1, wherein said retainer means is comprised of two wedge shaped members, each having a pair of generally parallel elongated legs joined at one end by a cross member and a serrated edge formed along the length of said legs, so that said wedge shaped members may combine along said serrated edges to form a jam fit.

26. The connector assembly according to Claim 3, wherein said first end of said housing includes an inwardly extending flange, forming a fourth diameter portion in said bore means, for mounting said retainer means to said housing.

27. The connector assembly according to Claim 26, wherein said retainer means is made from a resilient material, and comprised of a ring having an outer diameter approximately corresponding to said fourth diameter portion of said bore means, jaw means projecting from a first side of said ring, and converging at one end and extending beyond said outer diameter of said ring at another end, for providing said cooperation with said annular surface means of said conduit, and tab means projecting from a second side of said ring for positioning said retainer means at said first end of said housing.

28. The connector assembly according to Claim 27, wherein said flange of said housing is interposed between said tab means and said extending end of said jaw means when said retainer means is coupled to said housing.

29. The connector assembly according to Claim 28, wherein said jaw means is comprised of a pair of opposing angularly shaped jaw members.

30. The connector assembly according to Claim 29, wherein the distance between said jaw members at said converging end corre-

sponds approximately to the outside diameter of said conduit.

31. The connector assembly according to Claim 29, wherein said tab means is comprised of a pair of tab members positioned on opposite sides of said jaw members.

32. The connector assembly according to Claim 26, wherein said retainer means is made from a resilient material and comprised of a plurality of annular leg members centrally joined by recessed ring means for positioning said retainer means at said first end of said housing, said leg members each having a radially extending tab end on one side of said recessed ring means and a radially converging jaw end on another side of said recessed ring means.

33. The connector assembly according to Claim 32, wherein said retainer means is comprised of a pair of opposing annular leg members.

34. The connector assembly according to Claim 33, wherein said recessed ring means engages said flange of said housing when said retainer means is coupled to said housing.

35. The connector assembly according to Claim 34, wherein the distance between said annular leg members at said converging end corresponds approximately to the outside diameter of said conduit.

36. The connector assembly according to Claim 35, wherein a compression of said extending tab ends together provides for an extension of said converging ends sufficient to permit said conduit to be disconnected from said housing without removing said retainer means.

37. The connector assembly according to Claim 7, further including an annular spacer member disposed in said third diameter portion of said bore means and positioned between said elastomeric ring means and said second diameter portion of said bore means.

38. The connector assembly according to Claim 37, wherein said housing is made from an electrically conducting material, and said bushing means and said spacer member are made from an electrically non-conducting material.

39. The connector assembly according to Claim 38, wherein said spacer member prevents said connecting end of said conduit from contacting said housing at said second diameter portion of said bore means.

40. The connector assembly according to Claim 39, wherein said predetermined distance of said annular surface means from said conduit end to be connected corresponds approximately to the length of said third diameter portion of said bore means.

41. A swivable connector assembly for providing a snap-action quick connection, comprising:

130 a tubular conduit adapted to convey fluid

and formed with an annular projection disposed a predetermined distance from the end of said conduit to be connected;

5 a housing formed with an axial bore for receiving said conduit at a first end and for providing a fluid path at a second end, said housing including an inwardly extending annular lip at said first end;

10 sealing means disposed within said axial bore for providing a fluid tight seal between confronting portions of said conduit and said housing;

15 retainer means, disposed generally within said axial bore of said housing and detachably secure to said housing at said first end, for cooperating with said annular projection of said conduit to secure said conduit in its operative position within said axial bore of said housing, said retainer means including at

20 least two circumferentially spaced resilient deformable leg members extending from an integral collar member at one end thereof, each of said leg members having an outwardly opening channel portion adapted to receive said

25 inwardly extending annular lip of said housing for securing said retainer means to said housing and an inwardly opening channel portion adapted to receive said annular projection of said conduit for securing said conduit in its

30 operative position within said axial bore of said housing.

42. The swivable connector assembly according to Claim 41, wherein said leg members of said retainer means are adapted to

35 deform in response to the insertion of said retainer means into said axial bore of said housing and permit said annular lip of said housing to snap into said outwardly opening channel portion of each of said leg members.

40 43. The swivable connector assembly according to Claim 42, wherein said leg members of said retainer means are adapted to deform in response to the insertion of said conduit into said axial bore of said housing

45 and through said collar member of said retainer means and permit said annular projection of said conduit to snap into said inwardly opening channel portion of each of said leg members.

50 44. The swivable assembly according to Claim 43 wherein said leg members of said retainer means are adapted to be deflected inwardly for disengaging said annular lip of said housing from said outwardly opening

55 channel portions of said leg members and permitting said retainer means to be detached from said housing.

45. The swivable connector assembly according to Claim 44, wherein said collar

60 member of said retaining means is formed with an outwardly extending annular flange for positioning said sealing means within said axial bore of said housing.

46. The swivable connector assembly

65 according to Claim 44, wherein said connec-

tor assembly includes annular bushing means disposed within said axial bore of said housing for positioning said sealing means.

47. The swivable connector assembly

70 according to Claims 45 or 46, wherein said annular projection of said conduit has a shape generally complimentary to the shape of said inwardly opening channel portion of said retainer means.

75 48. The swivable connector assembly according to Claim 46, wherein said retainer means includes a plurality of circumferentially spaced, generally outwardly extending first tabs and said bushing means includes a plurality of circumferentially spaced, generally outwardly extending second tabs, said first and second tabs cooperating to maintain said retainer means in a partially installed position in said axial bore of said housing until said

80 85 annular projection of said conduit has snapped into said inwardly opening channel portion of each of said leg members of said retainer means, whereby further insertion of said conduit into said axial bore of said housing will cause said retainer means to move axially with said retainer means until said annular lip of said housing snaps into said outwardly opening channel portion of each of said leg members of said retaining means and

90 95 said conduit is in its operative position within said axial bore of said housing.

49. The swivable connector assembly according to Claim 47, wherein the first end of said housing has been rolled over to form

100 said annular lip.

50. The swivable connector assembly according to Claim 47, wherein said sealing means comprises a U-cap resilient ring.

51. The swivable connector assembly

105 according to Claim 47, wherein said retainer means is made from a plastic material.

52. The swivable connector assembly according to Claim 47, wherein said retainer means is made from a metal material.

110 53. The swivable connector assembly according to Claim 47, wherein said housing forms part of an integral cast body.

54. The swivable connector assembly

115 according to Claim 47, wherein said conduit is shaped such that said connector assembly provides an elbow connector assembly.

55. The swivable connector assembly

120 according to Claim 44 in combination with means for allowing fluid flow in a preferred direction and for blocking fluid flow in the opposite direction.

56. The swivable connector assembly

125 according to Claim 44 in combination with means for filtering particulate matter from the fluid flowing through said axial bore of said housing.

57. The swivable connector assembly

130 according to Claim 44 wherein said connector assembly is adapted to convey fluids under pressure.

58. The swivable connector assembly according to Claim 44 wherein said connector assembly is adapted to convey fluids under vacuum.

5 59. A swivable connector assembly for providing a snap-action quick connection, comprising:

10 a tubular conduit adapted to convey fluid and formed with an annular projection disposed a predetermined distance from the end of said conduit to be connected;

15 a housing formed with an axial bore for receiving said conduit at a first end and for providing a fluid path at a second end;

20 sealing means disposed within said axial bore for providing a fluid tight seal between confronting portions of said conduit and said housing;

25 retainer means, detachably secured to said housing generally at said first end, for cooperating with said annular projection of said conduit to secure said conduit in its operative position within said axial bore of said housing;

30 30 means for cooperating with said annular projection of said conduit to secure said conduit in its operative position within said axial bore of said housing;

35 60. The swivable connector assembly according to Claim 59, wherein said check valve means comprises:

40 a valve body formed with at least one passageway for selectively permitting fluid to flow therethrough;

45 sealing means, associated with said valve body, for blocking the flow of fluid from said second end of said housing through said passageway in said valve body when said conduit is not in its operative position within said axial bore of said housing; and

50 biasing means, engaging said valve body, for resiliently urging said valve body into a nesting relationship with said housing when said conduit is not in its operative position within said axial bore of said housing whereby said sealing means is operative to block fluid flow, and for permitting said valve body to be displaced axially from said nesting relationship

55 in response to the insertion of said conduit into said axial bore of said housing thereby permitting fluid flow through said passageway in said valve body when said conduit is in its operative position within said axial bore of

60 said housing.

61. The swivable connector assembly according to Claim 60, wherein said valve body of check valve means includes a plurality of generally axially extending, circumferentially spaced passageways.

62. The swivable connector assembly according to Claim 61, wherein said sealing means is an elastomeric ring seated in an annular groove of said valve body such that

70 when said conduit is not in its operative position within said axial bore of said housing said elastomeric ring is in sealing engagement with a neck portion of said housing.

63. The swivable connector assembly according to Claim 62, wherein said biasing means is a helical compression spring having one end thereof seated in a circular groove of said valve body and the other end in engagement with said housing.

75 64. For a connector assembly having a tubular conduit adapted to convey fluid and formed with an annular projection disposed a predetermined distance from the end of said conduit to be connected, a housing formed

80 with an axial bore for receiving said conduit at a first end and for providing a fluid path at a second end, sealing means for providing a fluid tight seal between confronting portions of said conduit and said housing, and

85 retainer means for cooperating with said annular projection of said conduit to secure said conduit in its operative position within said axial bore of said housing;

90 a disposable stuffer-plug adapted to install said sealing means in said axial bore of said housing and detachably secure said retainer means to said housing generally at said first end thereof comprising:

95 a body formed with a rod-shaped portion adapted to support said sealing means and said retainer means in a generally coaxial assembly relationship thereon and be inserted into said axial bore of said housing to seal said axial bore, and a facing portion extending

100 generally from one end of said rod-shaped portion and adapted to substantially cover said axial bore of said housing at said first end of said housing, said rod-shaped portion being formed with positioning means for maintaining said sealing means and said retainer means in said assembly relationship on said body until said stuffer-plug body is removed from said axial bore of said housing.

105 65. The disposable stuffer-plug according to Claim 64, wherein said rod shaped portion is generally tubular and has an outer diameter generally corresponding to that of said conduit.

110 66. The disposable stuffer-plug according to Claim 65, wherein said facing portion is a generally transversely extending plate formed with projection means for facilitating the removal of said stuffer-plug body from said axial bore of said housing.

115 67. The disposable stuffer-plug according to Claim 66, wherein said plate is circular and said projection means is a tab extending generally axially from said circular plate.

120 68. The disposable stuffer-plug according to Claim 64, wherein said sealing means and

125 130

5 said retainer means are disposed on said rod-shaped portion of said stuffer-plug body in said assembly relationship such that one end of said retainer means is positioned adjacent to said facing wall portion and said sealing means is positioned adjacent to the opposite end of said retainer means.

10 69. The disposable stuffer-plug according to Claim 68, wherein the facing portion provides a blocking surface upon which said retainer means is adapted to bear against when said stuffer-plug body is inserted into said axial bore of said housing, thereby causing said sealing means and said retainer means to be carried with said rod-shaped portion into said axial bore of said housing until said retainer means is detachably secured to said housing.

15 70. The disposable stuffer-plug according to Claim 69, wherein said positioning means of said rod-shaped portion of said stuffer-plug body operates to prevent said sealing means and said retainer means from slipping off said stuffer-plug body before said rod-shaped portion is inserted into said axial bore of said housing and yet permit said sealing means and said retainer means to slide off said rod-shaped portion when said stuffer-plug body is removed from said housing.

20 71. The disposable stuffer-plug according to Claim 70, wherein said positioning means is an annular groove adapted to seat said sealing means.

25 72. The disposable stuffer-plug according to Claim 71, wherein said positioning means of said rod-shaped portion of said stuffer-plug body also includes an annular projection, formed with at least one inclined surface, for cooperating with said retainer means to prevent said retainer means from slipping off said stuffer-plug body before said rod-shaped portion is inserted into said axial bore of said housing, said inclined surface being operative to facilitate the removal of said stuffer-plug body from said axial bore of said housing.

30 73. The disposable stuffer-plug according to Claim 70, wherein said stuffer-plug body is made from a plastic material.

35 74. For a connector assembly having a tubular conduit adapted to convey fluid and formed with an annular projection disposed a predetermined distance from the end of said conduit to be connected, a housing formed with an axial bore for receiving said conduit at a first end and for providing a fluid path at a second end, sealing means for providing a fluid tight seal between confronting portions of said conduit and said housing, and retainer means for cooperating with said annular projection of said conduit to secure said conduit in its operative position within said axial bore of said housing.

40 75. A removable disposable cover adapted to generally encompass the end of said conduit to be connected before said conduit is in-

serted into said axial bore of said housing to install said sealing means in said axial bore and detachably secure said retainer means to said housing comprising:

45 70 a resilient, flexible cover body having an aperture formed therein for permitting said cover body to pass over the end of said conduit to be connected and said sealing means, and for permitting said cover body to be subsequently removed when said conduit is to be inserted into said axial bore of said housing.

50 75. The disposable cover according to Claim 74, wherein said cover body is made from an elastomeric material.

55 76. For a connector assembly having a tubular conduit adapted to convey fluid and formed with an annular projection disposed a predetermined distance from the end of said conduit to be connected, a housing formed with an axial bore for receiving said conduit at a first end and for providing a fluid path at a second end, sealing means for providing a fluid tight seal between confronting portions of said conduit and said housing,

60 77. A retainer element adapted to be disposed generally within said axial bore of said housing and be detachably secured to said housing at said first end, for cooperating with said annular projection of said conduit to secure said conduit in its operative position within said axial bore of said housing,

65 78. The retainer element according to Claim 77, wherein said leg members of said retainer element are adapted to deform in response to the insertion of said retainer element into said axial bore of said housing and permit said annular lip of said housing to snap into said outwardly opening channel portion of each of said leg members.

70 79. The retainer element according to Claim 78, wherein said leg members of said retainer element are adapted to be deflected inwardly for disengaging said annular lip of

130 said housing from said outwardly opening channel portions of said leg members and permitting said retainer element to be detached from said housing.

135 5 80. The retainer element according to Claim 79, wherein said collar member of said retaining element is formed with an outwardly extending annular flange for positioning said sealing means within said axial bore of said housing.

140 10 81. The retainer element according to Claim 79, wherein said leg members are spaced circumferentially, such that a set of two of said leg members span a maximum of 180 degrees.

145 15 82. The retainer element according to Claim 81, wherein each of said leg members are equally spaced circumferentially, such that any two of said leg members span a maximum of 180 degrees.

150 20 83. The retainer element according to Claim 82, wherein the opposing axially extending edges of any two of said leg members form a substantially straight line.

155 25 84. The retainer element according to Claim 81, wherein said retainer element is made from a plastic material.

160 30 85. The retainer element according to Claim 81, wherein said retainer element is made from a metal material.

165 35 86. For a connector assembly having a housing formed with an axial bore for providing a fluid path, a pre-assembled connector conduit unit, comprising:

170 40 a tubular conduit adapted to convey fluid and formed with an annular projection disposed a predetermined distance from an end of said conduit to be inserted into said axial bore of said housing;

175 45 a retainer element disposed on said conduit in association with said annular projection of said conduit such that said retainer element is substantially fixed from axial movement in relation to said conduit, and adapted to be detachably secured to said housing so that said retainer element will secure said conduit in its operative position within said axial bore of said housing; and

180 50 sealing means disposed on said conduit between said end of said conduit to be connected and said retainer element for providing a fluid tight connection between confronting portions of said conduit and said housing when said conduit is inserted into said axial bore of said housing.

185 55 87. The pre-assembled connector conduit unit according to Claim 86, wherein the insertion of said conduit into said axial bore of said housing to unite said conduit and said housing will concomitantly install said sealing means in said axial bore and detachably secure said retainer element to said housing.

190 60 88. The pre-assembled connector conduit unit according to Claim 87, wherein said unit includes a removable disposable cover adapted to generally encompass at least the end of said conduit to be connected before said conduit is inserted into said axial bore of said housing.

195 65 70 89. The pre-assembled connector conduit unit according to Claim 87, wherein said unit includes bushing means, disposed on said conduit between said sealing means and said retainer element for positioning said sealing means within said axial bore of said housing.

200 75 90. For a connector assembly having a tubular conduit adapted to convey fluid and formed with an annular projection disposed a predetermined distance from the end of said conduit to be connected, a pre-assembled connector housing unit, comprising:

205 80 a housing formed with an axial bore for receiving said conduit at a first end and for providing a fluid path at a second end;

210 85 sealing means disposed within said axial bore for providing a fluid tight seal between confronting portions of said conduit and said housing; and

215 90 retainer means, disposed generally within said axial bore of said housing and detachably secured to said housing at said first end, for cooperating with said annular projection of said conduit to secure said conduit in its operative position within said axial bore of said housing by a one-step snapping connection therewith.

220 95 91. The pre-assembled connector housing unit according to Claim 90, wherein said unit includes bushing means, disposed within said axial bore of said housing between said sealing means and said retainer means, for positioning said sealing means within said axial bore of said housing.

225 100 92. For a connector assembly having a tubular conduit adapted to convey fluid and formed with an annular projection disposed a predetermined distance from the end of said conduit to be connected, a housing formed with an axial bore for receiving said conduit at a first end and for providing a fluid path at a second end, a stuffer-plug unit, comprising:

230 105 a disposable stuffer-plug body formed with a rod-shaped portion adapted to be inserted in said axial bore of said housing at said first end thereof, and a facing portion extending generally from one end of said rod-shaped portion and adapted to substantially cover said axial bore of said housing at said first end thereof; at least one sealing element disposed on

235 110 120 said rod-shaped portion of said stuffer-plug body and adapted to provide a fluid tight seal between confronting portions of said conduit and said housing; and

240 115 a retainer element disposed on said rod-shaped portion of said stuffer-plug body between said sealing element and said facing portion of said stuffer-plug body, and adapted to be detachably secured to said housing and cooperate with said annular projection of said conduit to secure said conduit in its operative

position within said axial bore of said housing.

93. The stuffer-plug unit according to Claim 92, wherein the insertion of said rod-shaped portion of said stuffer-plug body into 5 said axial bore of said housing is operative to install said sealing means in said axial bore of said housing, create a fluid tight seal between confronting portions of said rod-shaped portion of said stuffer-plug body and said housing, and detachably secure said retainer element to said housing generally at said first end thereof.

94. The stuffer-plug unit according to Claim 93, wherein said rod-shaped portion is 15 formed with positioning means for maintaining said sealing element and said retainer element in said assembly relationship on said stuffer-plug body until said stuffer-plug body is removed from said axial bore of said housing.

95. A swivelable connector assembly constructed and arranged to operate substantially as hereinbefore described with reference to and as illustrated in Figs. 15 to 36 of the 20 accompanying drawings.

96. A stuffer-plug constructed and arranged substantially as hereinbefore described with reference to and as illustrated in Figs. 22 and 23 of the accompanying drawings.

97. A pre-assembled connector conduit 30 unit constructed and arranged to operate substantially as hereinbefore described with reference to and as illustrated in Figs. 24 to 26 of the accompanying drawings.